

Work Order ID 64241

Tuesday, November 30, 2010 1:41:34 PM



Page 1

Item ID: D4271-011
Revision ID: PRELIM
Item Name: Fwd Beam Assembly

Accept



Setup Start



Stop



Start Date: 11/30/2010 Start Qty: 1.00
Required Date: 12/1/2010 Req'd Qty: 1.00



Cust Item ID:
Customer:

PRELIMINARY ISSUE

Reference:

Approvals: Process Plan: mf Date: 10-11-30 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D4271 | P/A | | | | | | | | |
| 100 | | 0.00 | | | | | | | |
| | | | | | | | | | |
| Small Fab | Memo | 0.00 | | | | | | | |
| Small Fab | 1- Pick and Assemble as per dwg | | | | | | | | |
| 110 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 120 | Identify as per dwg & Stock Location: _____ | 0.00 | | | | | | | |
| | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |

EP 10/12/01 ①

— inspect to P42 hatching
Dwg
8/10/12/01
-01

10/12/11

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



Work Order ID 64241


Tuesday, November 30, 2010 1:41:34 PM



Page 2

Item ID: D4271-011 Accept  Setup Start 
Revision ID: PRELIM Stop 
Item Name: Fwd Beam Assembly
Start Date: 11/30/2010 Start Qty: 1.00  Cust Item ID:
Required Date: 12/1/2010 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130  | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| QC Quality Control | Memo | 0.00 | | | | | | | |

test only Rev PA2
10.12.03

POSITIVE RES

EFFECTIVE

RELEAS.

MF
10-12-06

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

Tuesday, November 30, 2010 1:41:33 PM

Work Order ID: 64241

Parent Item: D4271-011

Parent Item Name: Fwd Beam Assembly





Start Date: 11/30/2010

Required Date: 12/1/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.11.18 new issue DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| D4149-5 - PDI  Eyebolt Stud | | Manufactured | No | | | 100 | Each | 7.0000 | 1 | 1 | | | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | |
| | | | | GA | | | 7 | | | | | | |
| | | | | | 61234 | | 7 | | | | | | |
| D4274-1 - PDI  Plate, Fwd Support | | Manufactured | No | | | 100 | Each | 2.0000 | 2 | 2 | | | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | |
| | | | | WA | | | 2 | | | | | | |
| | | | | | 63884 | | 2 | | | | | | |
| ✓ D4275-1  Fwd Beam | | Manufactured | No | | | 100 | Each | 1.0000 | 1 | 1 | | | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | |
| | | | | WA | | | 1 | | | | | | |
| | | | | | 63881 | | 1 | | | | | | |
| ✓ D4281-1  Spacer | | Manufactured | No | | | 100 | Each | 3.0000 | 1 | 1 | | | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | |
| | | | | ENG | | | 3 | | | | | | |
| | | | | | 63886 | | 3 | | | | | | |

EP 12/1/01
B64213 (14)

EP 12/1/01
B64216 (24)

EP 12/1/01
1

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, November 30, 2010 1:41:33 PM

Page 2

Work Order ID: 64241

Parent Item: D4271-011

Parent Item Name: Fwd Beam Assembly

Start Date: 11/30/2010

Required Date: 12/1/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C12A

Purchased

No

100

Each

21.0000

8

8



Bolts

Location

Loc Qty

Loc Code

ST351

21

112314

8

114761

11

116022

2



Ep 10/12/01 (6)
1116289 (8x)
PJO

MS20615-4M18

Purchased

No

100

Each

357.0000

8

8



Rivet

Location

Loc Qty

Loc Code

ST323

357

114808

152

115037

205



Ep 10/12/01
8

MS21043-3

Purchased

No

100

Each

1,896.000

8

8



Nut

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

1820

112314

1820



Ep 10/12/01 (6)
8

Tuesday, November 30, 2010 1:41:33 PM

Shop Packet Print

Page 2

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|----------|------|---|----|----------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 10/12/01 | 100 | AN4C13A. m <u>4114615</u> x B 4 NA51149C0432R <u>4114742</u> x 16 8 m521043-4 <u>4116188</u> x B 4 | EP | 10/12/01 | ① | ND 10/12/01 | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, November 30, 2010 1:41:33 PM

Work Order ID: 64241



Parent Item: D4271-011



Parent Item Name: Fwd Beam Assembly

Start Date: 11/30/2010

Required Date: 12/1/2010

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

100

Each

3,445.000

16

16



Washer



EB 10/12/01 (12)

Location

Loc Qty

Loc Code

ST297

3445

115000

125

115698

35

115832

1285

116025

2000

16

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

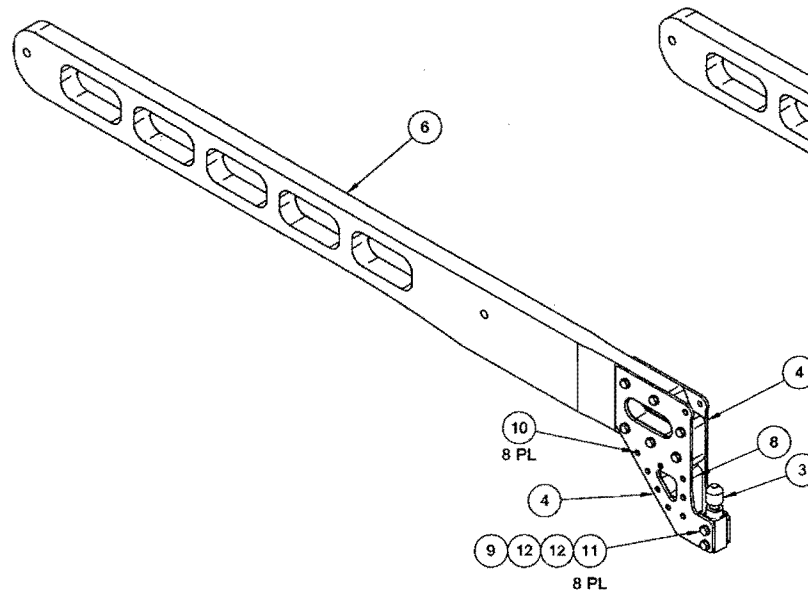
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

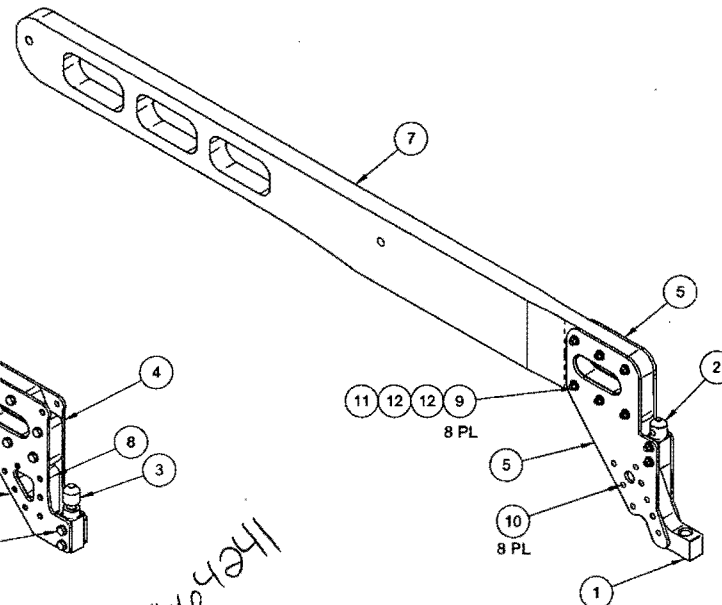
| ITEM | QTY -011 | QTY -013 | PART NUMBER | DESCRIPTION |
|------|-------------|-------------|---------------|--------------------|
| | | | D4271-011 | FWD BEAM ASSY |
| | | | D4271-013 | AFT BEAM ASSY |
| 1 | | 1 | D4148-3 | STUD RECEIVER |
| 2 | | 1 | D4148-5 | EYEBOLT STUD |
| 3 | 1 | | D4149-5 | EYEBOLT STUD |
| 4 | 2 | | D4274-1 | PLATE, FWD SUPPORT |
| 5 | | 2 | D4274-3 | PLATE, AFT SUPPORT |
| 6 | 1 | | D4275-1 | FWD BEAM |
| 7 | | 1 | D4276-1 | AFT BEAM |
| 8 | 1 | | D4281-1 | SPACER |
| 9 | 8 | 8 | AN3C12A | BOLT |
| 10 | 8 | 8 | MS20615-4M18 | RIVET |
| 11 | 8 | 8 | MS21043-3 | NUT |
| 12 | 16 | 16 | NAS1149C0332R | WASHER |

72 22 AN4C13A
 84 84 AN4C13A 0432R
 72 72 MS21043-4

MD 10/12/01



D4271-011 FWD BEAM ASSEMBLY



D4271-013 AFT BEAM ASSEMBLY

PRELIMINARY ISSUE
 Nov 17, 2010 fl.

| | | | |
|------------|-------------|--|--------------|
| PA1 | PRELIMINARY | JPH | 10.11.12 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | JPH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | JPH | | |
| CHECKED | JPH | DRAWING NO. | REV. BAY |
| MFG. APPR. | JPH | D4271 | SHEET 1 OF 2 |
| APPROVED | JPH | TITLE | SCALE |
| DE APPR. | JPH | SUPPORT BEAM ASSEMBLIES | NTS |
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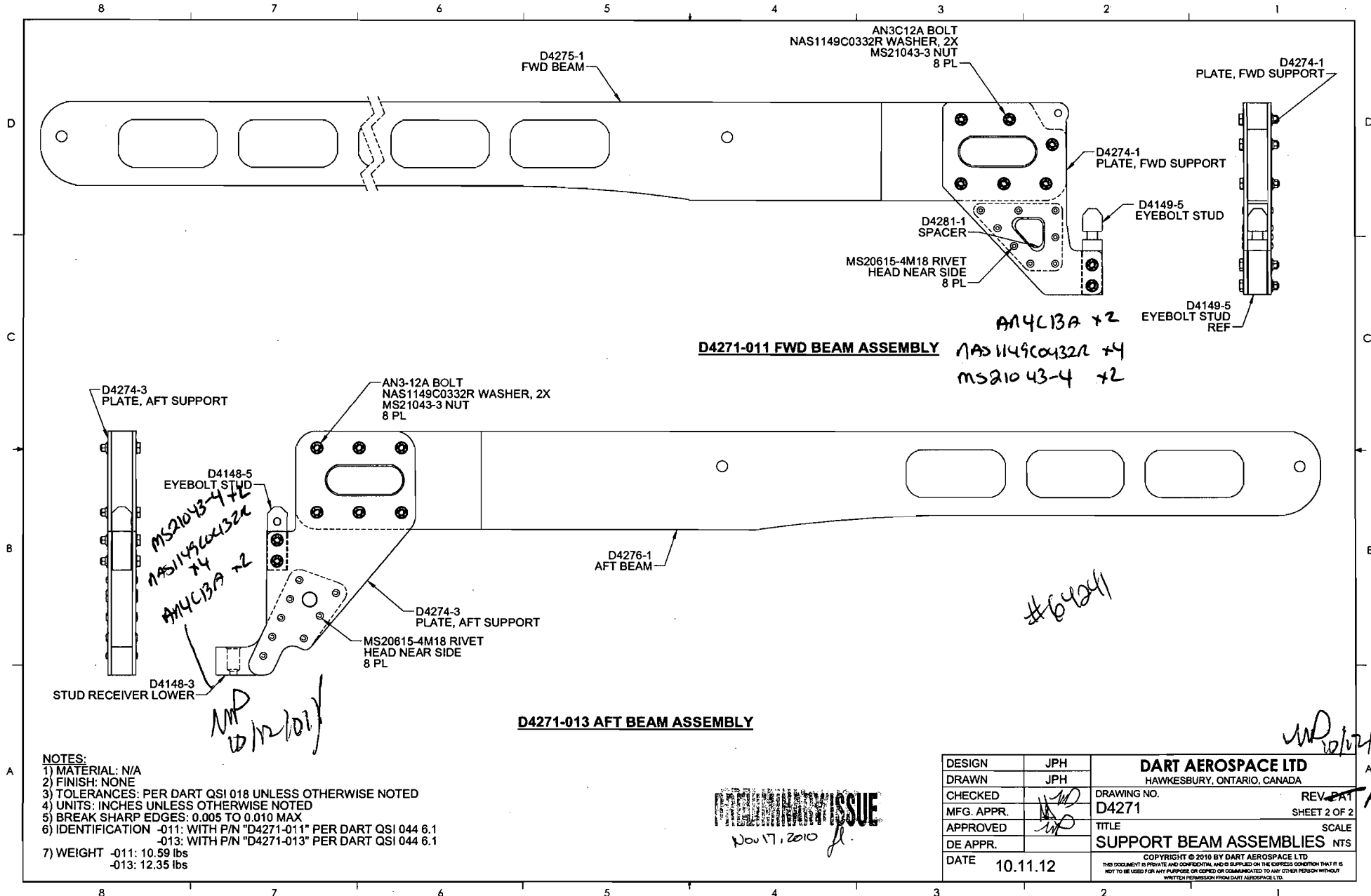
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



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| DRAWN | JPH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | JPH | DRAWING NO. | REV. 01 |
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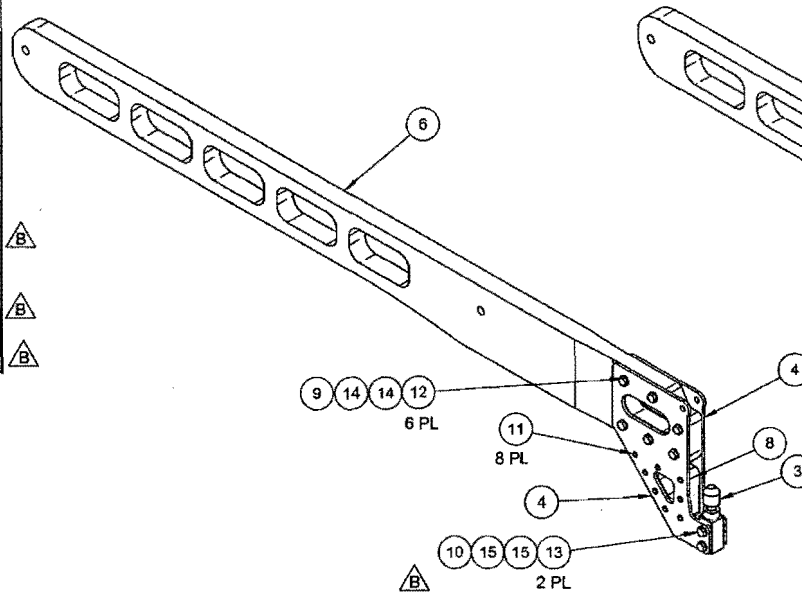
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

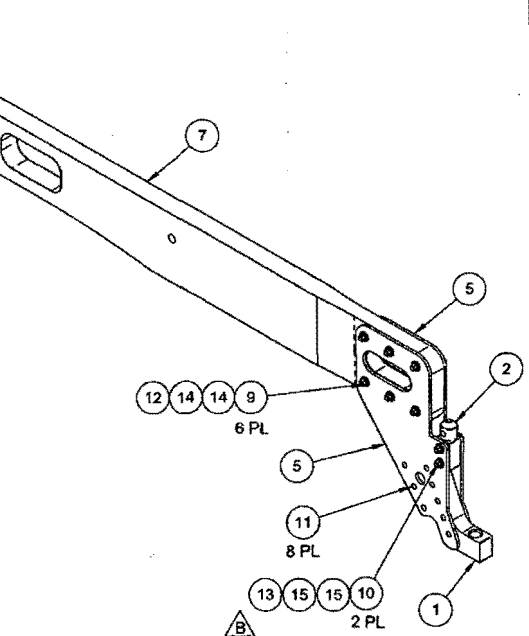
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NOTE: Date & initial all entries

| ITEM | QTY -011 | QTY -013 | PART NUMBER | DESCRIPTION |
|------|-------------|-------------|---------------|--------------------|
| | | | D4271-011 | FWD BEAM ASSY |
| | | | D4271-013 | AFT BEAM ASSY |
| 1 | | 1 | D4148-3 | STUD RECEIVER |
| 2 | | 1 | D4148-5 | EYEBOLT STUD |
| 3 | 1 | | D4149-5 | EYEBOLT STUD |
| 4 | 2 | | D4274-1 | PLATE, FWD SUPPORT |
| 5 | | 2 | D4274-3 | PLATE, AFT SUPPORT |
| 6 | 1 | | D4275-1 | FWD BEAM |
| 7 | | 1 | D4276-1 | AFT BEAM |
| 8 | 1 | | D4281-1 | SPACER |
| 9 | 6 | 6 | AN3C12A | BOLT |
| 10 | 2 | 2 | AN4C13A | BOLT |
| 11 | 8 | 8 | MS20615-4M18 | RIVET |
| 12 | 6 | 6 | MS21043-3 | NUT |
| 13 | 2 | 2 | MS21043-4 | NUT |
| 14 | 12 | 12 | NAS1149C0332R | WASHER |
| 15 | 4 | 4 | NAS1149C0432R | WASHER |



D4271-011 FWD BEAM ASSEMBLY



D4271-013 AFT BEAM ASSEMBLY

| | | | |
|------------|---|---|--------------|
| B | ITEM 10 CHANGED FROM AN3C12A TO AN4C13A | SC | 10.12.01 |
| A | NEW ISSUE | SC | 10.11.25 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | JPH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | SC | | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D4271 | SHEET 1 OF 2 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | SUPPORT BEAM ASSEMBLIES | NTS |
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